

Date: Monday, 18/08/2008 3:45:08 PM
 User: Julie Lecocq

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	AFT ADJUSTABLE BLADE SUPPORT ASSY
Job Number :	41368		
Estimate Number :	13434		
P.O. Number :		Part Number :	PB674300117
This Issue :	18/08/2008	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	B6743001 P.7
First Issue :	/ /	Project Number :	N/A
Previous Run :	40609	Drawing Revision :	B1
	Type :	Material :	
	LARGE FAB ASSY	Due Date :	18/09/2008
Written By :		Qty:	8 Um: Each
Checked & Approved By :	JUL 08 8-18		
Comment :	Est Rev:A 08-06-26 new issue DD verified by:ec		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PB6743001259	Inner Tube
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)

Inner Tube

batch: 41496

08-09-26 2

2.0	PB6743001249	Inner Tube Bushing
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)

Inner Tube Bushing

batch: 823434

08-09-26 2

3.0	PB6743001253	Gusset
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)

Gusset

batch: 40717 41492

08-09-26 2

4.0	PB6743001254	Gusset
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)

Gusset

batch: 40053 41493

08-09-26 2

5.0	PB674300171	PB67-43001-71
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)

PB67-43001-71

batch: 41812

08-09-26 2

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 18/08/2008 3:45:08 PM
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Part Number: PB674300117

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Seq. #: Machine Or Operation: Description :

6.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1- make a 0.090" chamfer in the 1.00" hole before welding

2- assemble parts and weld as per dwg

08.09.29 2

7.0 QC9 VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

08.09.29 *08.09.29*

8.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/09/09 (F2)

9.0 MS124780 HELICAL INSERT



Comment: Qty.: 1.0000 Each(s)/Unit Total: 8.0000 Each(s)

HELICAL INSERT

323434 *17935*

08.09.29 2

10.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- grind weld flush in area of PB67-43001-249 only

2- install helicol insert as per dwg

08.09.29 2

08.09.29 2

11.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/09/09 (F2)

12.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

1/4 *5* *08/09/30*

13.0 POWDER COATING POWDER COATING



Comment: POWDER COATING

1- MASK TUBE FROM BASE TO GUSSET

2- Powder Coat Green Sandtex (Ref: 4.3.5.8) as per QSI 005 4.3

M 102316 (2X)

m.h *08/09/30*

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

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Drawing Name: AFT ADJUSTABLE BLADE SUPPORT ASSY

Job Number: 41368

Part Number: PB674300117

Job Number:



Seq. #:

Machine Or Operation:

Description :

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

9:00
320 OF
9:30

m.p. 08/04/30 (2X)

14.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08-04-30 (2)

15.0

PB674300173

20 Degree Cover Plate



Comment: Qty.: 1.0000 Each(s)/Unit Total: 8.0000 Each(s)
20 Degree Cover Plate
batch: B41513 x4

Cpl 08.10.22

16.0

PB674300183

PB67-43001-83



Comment: Qty.: 1.0000 Each(s)/Unit Total: 8.0000 Each(s)
PB67-43001-83
batch: B41516 x4

Cpl 08.10.22

17.0

MS27039110

Screw



Comment: Qty.: 8.0000 Each(s)/Unit Total: 32. 64.0000 Each(s)
Screw
batch: m109031

Cpl 08.10.22

18.0

NAS1149F0316P

WASHER



Comment: Qty.: 8.0000 Each(s)/Unit Total: 32. 64.0000 Each(s)
WASHER
batch: m109031

Cpl 08.10.22

19.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1
1- match drill cover to existing holes in support
2- assemble as per dwg

Cpl 08.10.22

(X) (X)

W/O:		WORK ORDER CHANGES					
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QA: N/C Closed: _____ Date: _____

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Job Number:



Seq. #:

Machine Or Operation:

Description :

20.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/10/23 (x2)

21.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

can welding 08/10/23 (x2)

22.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/10/23 (x2)

Job Completion



mf 08-10-23

Dart Aerospace Ltd

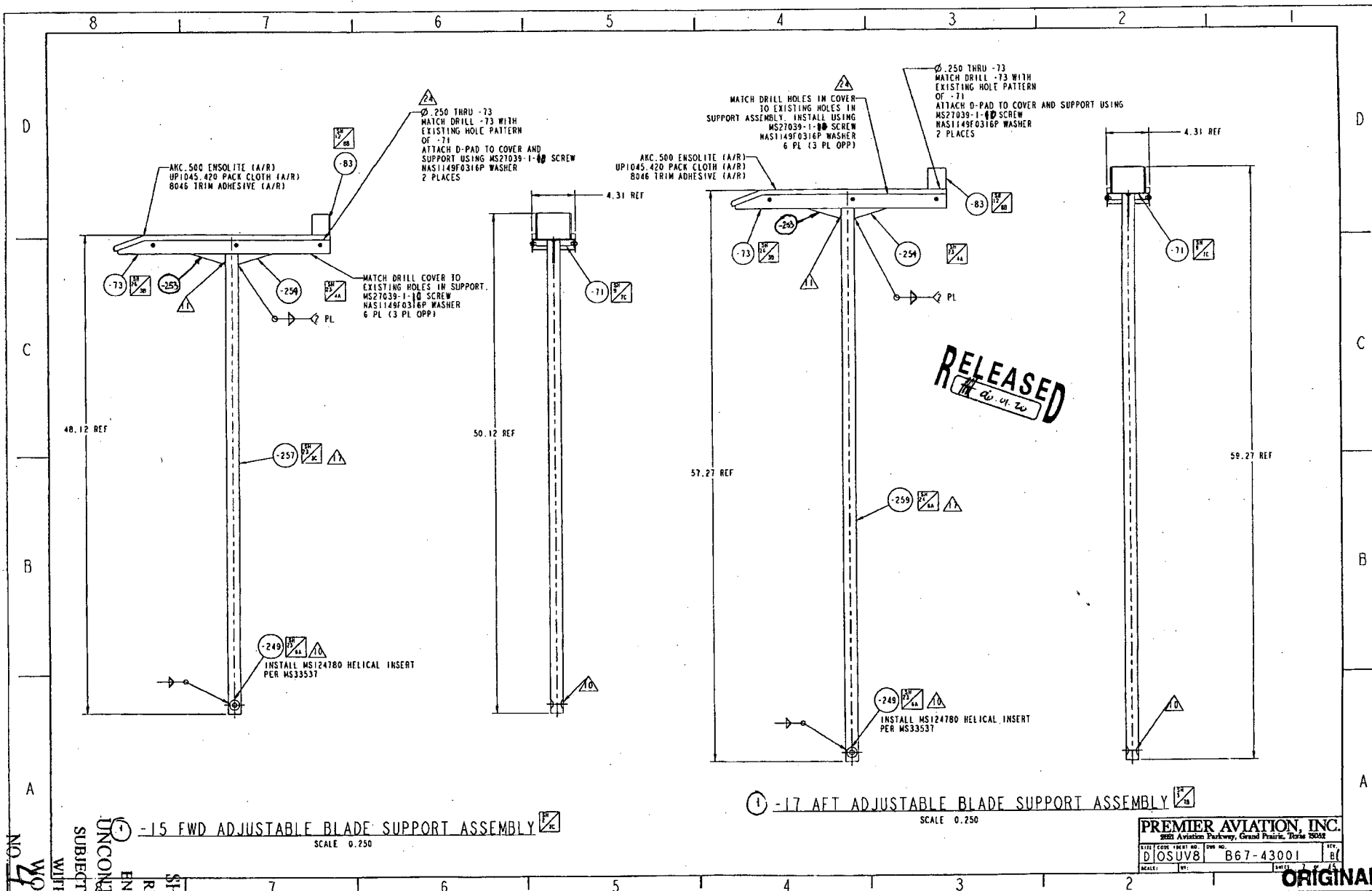
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



NO. 41308
WORK ORDER
WITHOUT NOTICE
SUBJECT TO AMENDMENT
UNCONTROLLED COPY
ENGINEERING
RETURN TO
SHOP COPY
15